

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017851**Date Inspected:** 07-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG TRIAL ASSEMBLY YARD

WELDING:

Segment 11DW~ 11EW

This QA Inspector observed ZPMC qualified welding personnel identified as 040656 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE11C-008; located On Orthotropic Box Girder (OBG) Bottom Plate to Bottom Plate Transverse CJP Weld. ZPMC QC is identified as Mr.Zhu Yuan Yuan. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with applicable WPS-B-P-2214-B-U2-FCM-1. See attached Photo for further details.

Segment 11BE

This QA Inspector observed ZPMC qualified welding personnel identified as 050289 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG068C-001; located On Orthotropic Box Girder (OBG)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Longitudinal Diaphragm to Floor Beam CJP Weld. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with applicable WPS-B-P-2214-TC-U4b-FCM-1.

Segment # 11CE ~ 11DE

This QA Inspector observed ZPMC qualified welding personnel identified as 040320 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA088-002; located On Orthotropic Box Girder (OBG) Deck Plate to Edge Plate Hold Back CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-TC-U4b-FCM-1. See attached Photo for further details.

Segment # 11CE

This QA Inspector observed ZPMC qualified welding personnel identified as 040265 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG070A-012; located On Orthotropic Box Girder (OBG) Side Plate to Bottom Plate Hold Back CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-B-U2-FCM-1.

Segment # 11CE ~ 11DE

This QA Inspector observed ZPMC qualified welding personnel identified as 053486 perform Flux Core Arc Welding (FCAW), weld joint identified as SP785-001-025; located On Orthotropic Box Girder (OBG) Side Plate T-Rib Hold Back Weld; ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

NDT:

Segment # 11AE ~ 11BE

This QA Inspector performed Magnetic Particle Testing (MPT) Verification inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MPT report for this date. The members are identified as Orthotropic Box Girder (OBG) components. The weld designations verified are as follows.

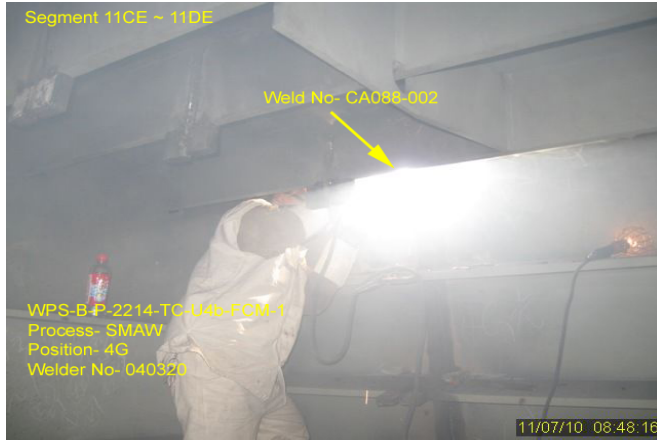
SP714-001-025, 026
SP715-001-015, 016
EP170-001-009, 010
EP171-001-005, 006
DP717-001-015, 016
DP718-001-009, 010
SEG068C-041,043,044,045,057,065.
SEG066C-008.

Nondestructive testing (NDT) notification No. 07261

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.



Summary of Conversations:

No significant conversation were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
